

Work Order ID 63694

November 10, 2010 9:09:14 AM



Page 1

Item ID: D4211-045

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate, Aft

Start Date: 11/10/10 Start Qty: 10.00



Cust Item ID:

Required Date: 11/15/10 Req'd Qty: 10.00



Customer:

Reference:

W

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4211

B

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg ***Make from D4211-5F***

Dwg Rev: *B*

Prog Rev: *B*

2-Deburr if necessary

B 10-11-11

(10)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 10-11-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63694

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Page 2

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8/10/11

4/0

130

Form as per dwg

0.00



Brake NC

Memo

0.00

Brake NC

SB 10/11/17

10

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/17

4/0

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Weld per dwg A/R Hardcoat S.S. Batch: *M116044*

0.00

Large Fab

AT9696
10.11.23 Memo

0.00

Large Fab

EL 10-11-23

(K10)

160

~~QC9~~ Inspect visual per QSI004- Fusion Welds

0.00

QC

QC10
8 Memo
10/11/23

0.00

Quality Control

S 10/11/23

Pho ->

165

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

S 10/11/23

(K10)
-45

W/O: 63694

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		Perm. change					
10/11/23	#160	change to A ACIO. to have consistency with other work plates	<i>[Signature]</i>	10.11.26			<i>[Signature]</i> 10/11/23

Part No: D4211-045 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 63694

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Start Date: 11/10/10 Start Qty: 10.00



Cust Item ID:

Required Date: 11/15/10 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170



Powdercoat

Powder Coating

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

M112588

0.00

=> JU 10/11/24

0.00

10

8

Memo

Start Time: 9:30 AM

Oven Temperature: 320°C

Finish Time: 10:00 AM

180



QC

Quality Control

QC3- Inspect Part Finish

0.00

0.00

Memo

12/11/24 SP 10x

190



Packaging

Packaging

Identify as per dwg & Stock Location: 137

0.00

0.00

Memo

12/11/24 SP 10x

W/O:		WORK ORDER CHANGES					
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Work Order ID 63694

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/11/25 JG

ME
10-11-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

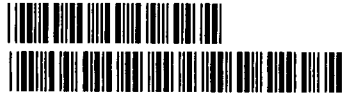
November 10, 2010 9:09:13 AM

Page 1

Work Order ID: 63694

Parent Item: D4211-045

Parent Item Name: Wearplate, Aft



Start Date: 11/10/10

Required Date: 11/15/10

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 10.11.04 as per revB DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	170.6000	0.1366	1.437895			



304/316 Sheet .063



B 10-11-11

Location

Loc Qty

Loc Code

MAT

170.6

111323

0

115688

10.6

115953

160

115688

10

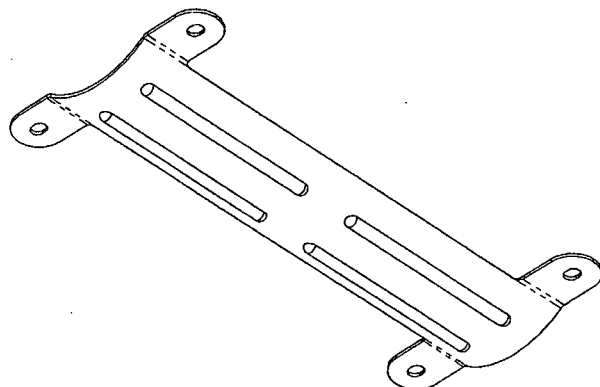
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

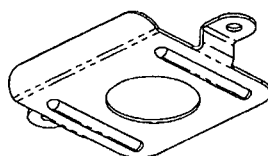
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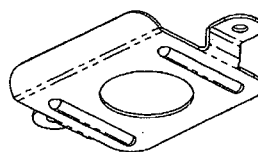
NOTE: Date & initial all entries



D4211-041 WEARPLATE



△ D4211-043 AFT WEARPLATE



△ D4211-045 AFT WEARPLATE

do 63694

RELEASED
2010-11-03

B	REDESIGNED D4211-043 AND CREATED D4211-045.	MB	10.10.15
A	NEW ISSUE	MB	10.09.30
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.10.15		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4211	REV. B
TITLE 429 WEARPLATE	SCALE NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

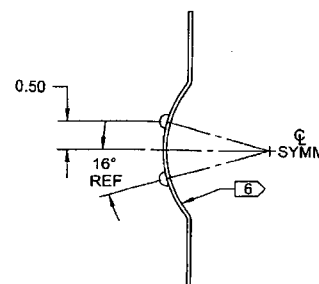
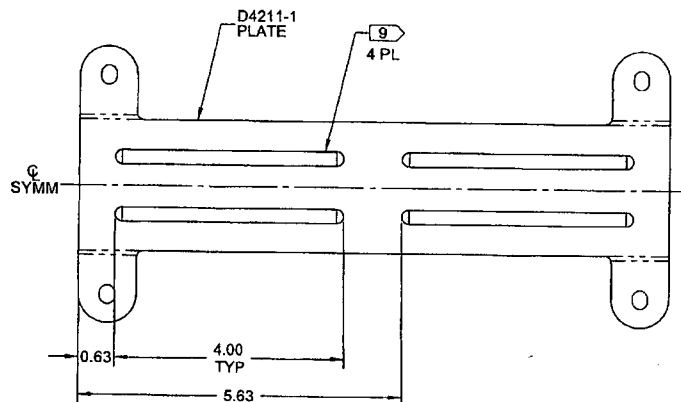
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

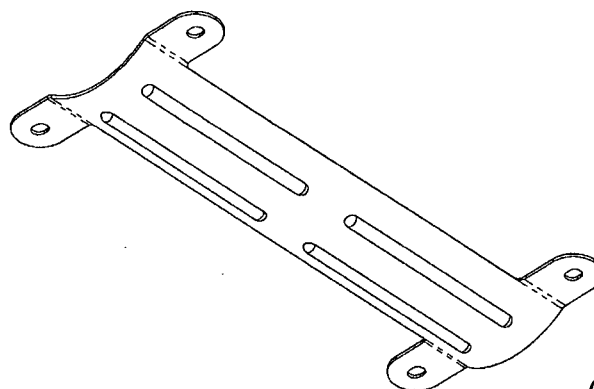
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4211-041	WEARPLATE
1	1	D4211-1	PLATE
2	A/R	2059B	HARDCOAT



D4211-041 WEARPLATE



RELEASED
2010-11-03

D4211-041 NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: POWDER COAT "BLACK SANDEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4211-041" AND B/N "BXXXXX" PER DART QSI 044 6.1
- 7) WEIGHT: 0.64 lbs
- 8) WELDING: PER DART QSI 004
- 9) 2059B HARDCOAT WELD, 0.063 TO 0.125 HIGH

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4211	SHEET 2 OF 6
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63694

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

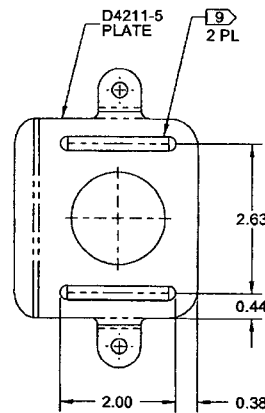
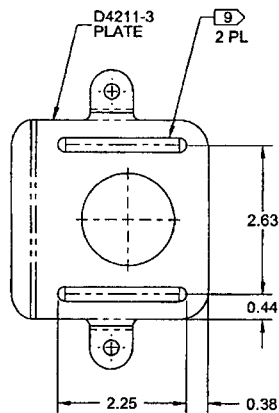
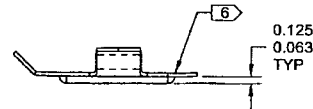
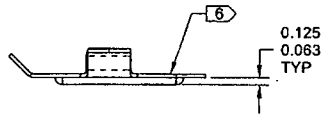
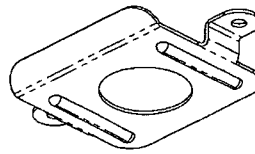
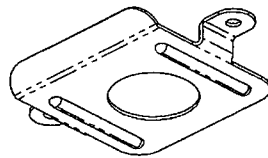
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NOTE: Date & initial all entries

ITEM	QTY -043	QTY -045	P/N	DESCRIPTION
	X		D4211-043	AFT WEARPLATE
		X	D4211-045	AFT WEARPLATE
1	1		D4211-3	PLATE
2		1	D4211-5	PLATE
3	A/R	A/R	2059B	HARDCOAT



D4211-043 AFT WEARPLATE

D4211-045 AFT WEARPLATE

D4211-043/-045 NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4211-04X" AND B/N "BXXXX" PER DART QSI 044 6.1
- 7) WEIGHT: 0.24 lbs
- 8) WELDING: PER DART QSI 004
- 9) 2059B HARDCOAT WELD, 0.063 TO 0.125 HIGH

RELEASED
2010-11-03

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESSBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4211	REV. B
MFG. APPR.			SHEET 3 OF 6
APPROVED		TITLE 429 WEARPLATE	SCALE
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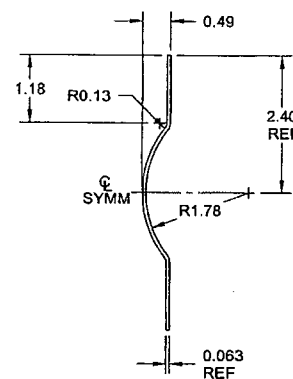
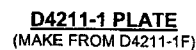
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			


NOTE: Date & initial all entries



RELEASE
2010-11-03
MD

D4211-1/-1F NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S16GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.64 lbs

DESIGN			DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			DRAWING NO.	REV. B
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DATE	10.10.15			

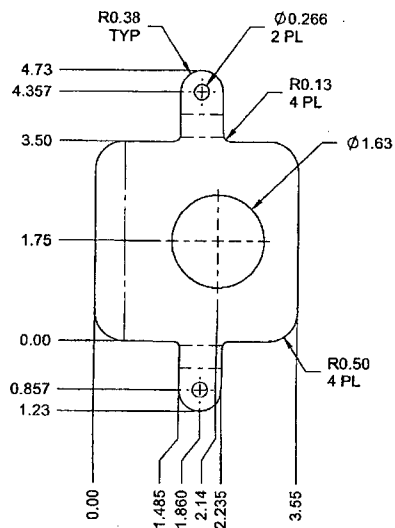
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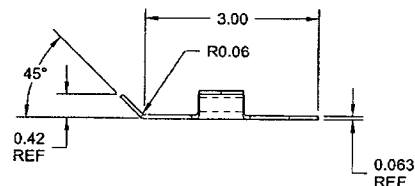
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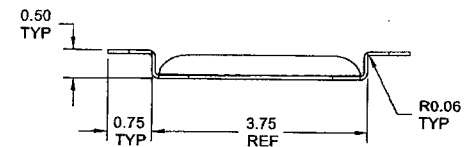
NOTE: Date & initial all entries



D4211-3F FLAT PATTERN (1)



D4211-3 PLATE
(MAKE FROM D4211-3F)



D4211-3/3F NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S16GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.24 lbs

63694

RELEASE
2010-11-03

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4211	SHEET 5 OF 6
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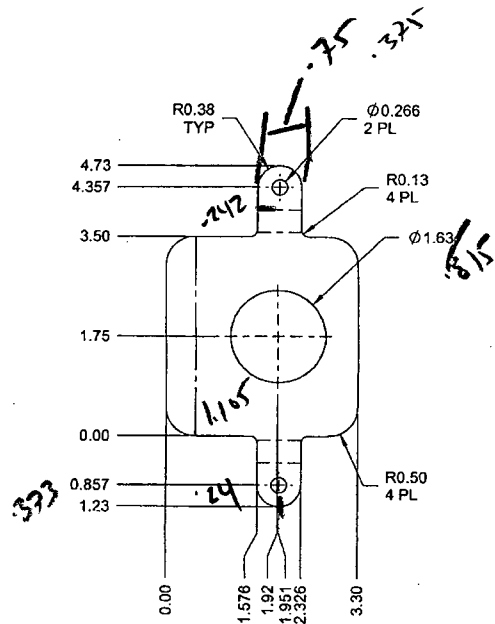
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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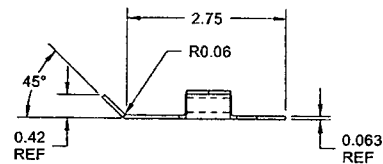
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

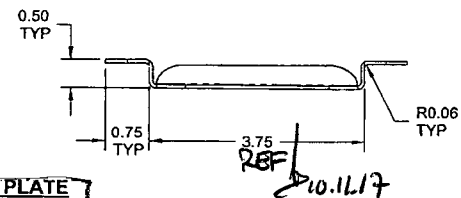
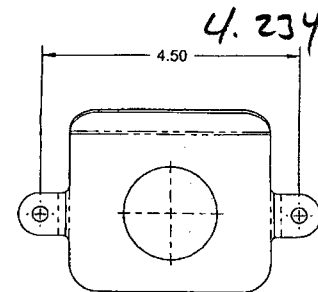
NOTE: Date & initial all entries



D4211-5F FLAT PATTERN



D4211-5 PLATE
(MAKE FROM D4211-5F)



RELEASED
2010-11-03

D4211-5/5F NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S16GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.22 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4211	SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		429 WEARPLATE	NTS
DATE	10.10.15	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries